

Date: Thursday, 19/03/2009 4:30:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 84 BRACKET
Job Number : 46611	
Estimate Number : 11035	
P.O. Number :	Part Number : D28032
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D2803 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 46436	Material :
Written By :	Due Date : 31/03/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 09.03.19</u>	
Comment : Est. A 00.11.06 New Issue EC Est Rev:B Blanks now cut on Waterjet 06-06-14 JLM Est Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .500 x 10.00
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OUT of MAT.



Comment: Qty.: 2.0125 f(s)/Unit Total: 20.1254 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: 109288

B 9-4-4

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Template DT8533

Dwg Rev: BProg Rev: B

B 9-4-4

~~A~~ (10)

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(10)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

H.A 09/04/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/04/10

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

H.A 09/04/13

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:30:43 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 46611

Part Number: D28032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



10

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 02/04/13

7.0

PACKAGING 1

PACKAGING RESOURCE #1



10x

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 148

9/4/14

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 H

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.04.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>H 6001</i>
Description: Bracket		Part Number: D2803-2
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø 0.759	✓			
1.420	+/-0.001	1.420	✓			
Ø0.191	+0.005/-0.000	Ø 0.193	✓			
Ø0.507	+0.000/-0.001	Ø 0.5060	✓			
Ø0.507 x 0.250	+0.000/-0.001	Ø 0.5060 x .251	✓			
12.411	+/-0.010	12.411	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	0.251	✓			
0.875	+0.000/-0.001	0.8750	✓			
0.250	+0.000/-0.005	0.248	✓			
0.125	+/-0.010	0.126	✓			
0.125	+/-0.010	0.128	✓			
0.500	+/-0.010	0.491	✓			
0.125	+/-0.010	0.128	✓			
0.188	+/-0.010	0.188	✓			
0.562	+/-0.010	0.563	✓			
0.125	+/-0.010	0.126	✓			

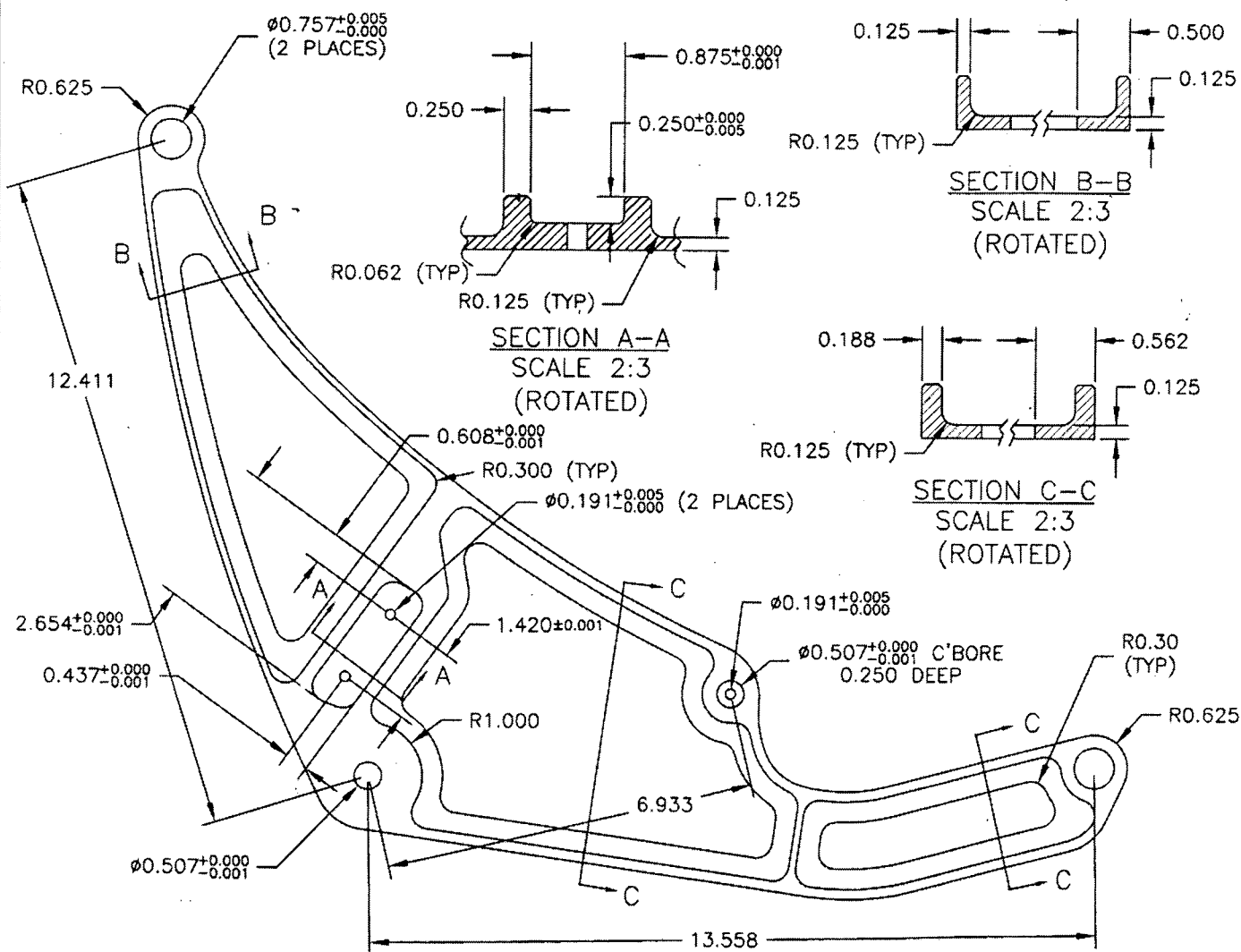
Measured by: <i>H.A.</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 09/04/10	Date: 09/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

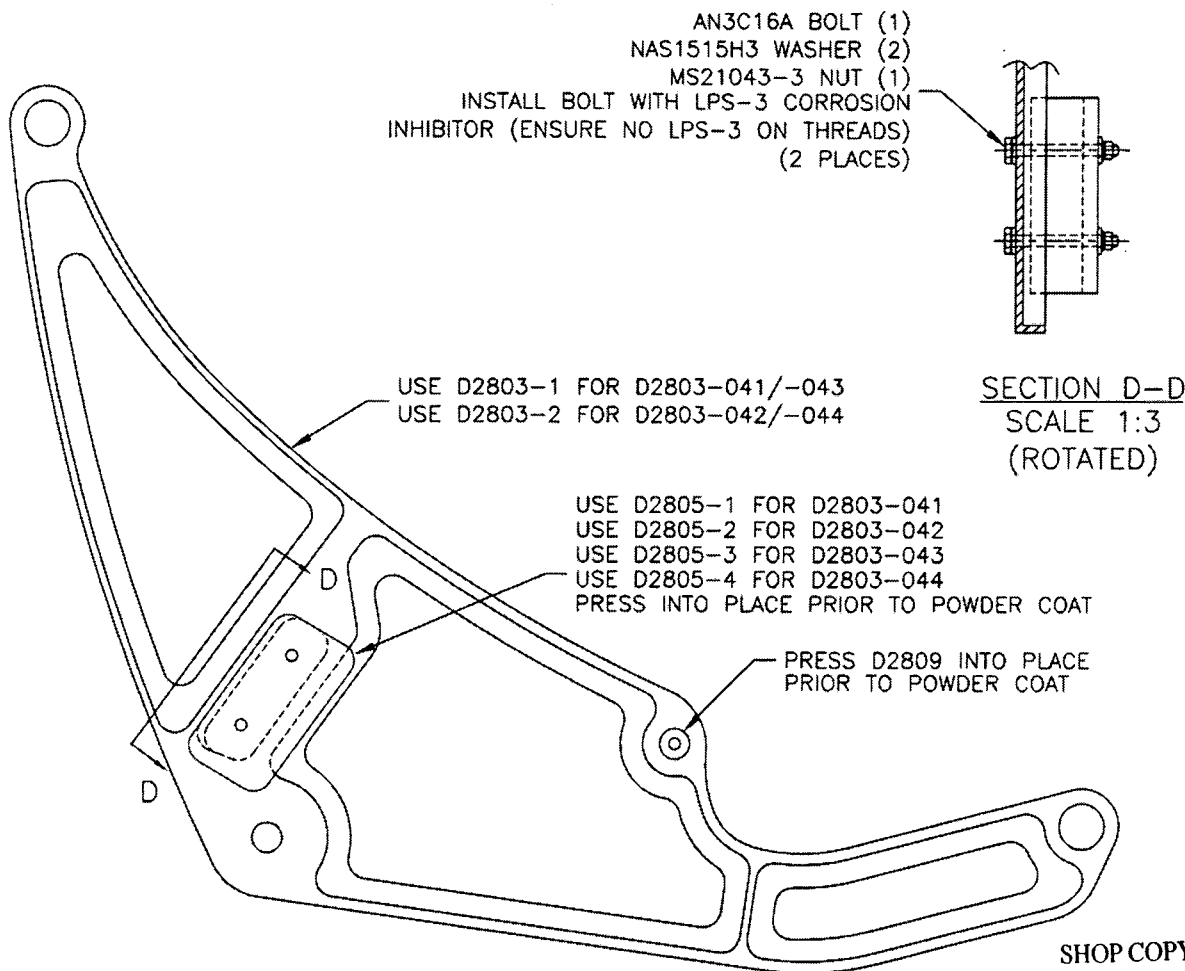
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



SECTION D-D
SCALE 1:3
(ROTATED)

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05-03-11 W/ K. OPPER
NO. 14/1001

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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